

Work Order ID 166246

Wednesday, September 13, 2017 11:07:26 A

166246

Page 1

Item ID: D3505-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Web
Start Date: 9/13/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 9/18/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: DAS 21 Date SEP 13 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3505	Rev A								

100

100

Skidtubes

Skidtubes

Skidtubes

Memo

1-Cut to Length as per Dwg D35052-Drill Pilot Holes using DT8869 Drill
Jig3-Open pilots to 1.000" as per Dwg D35054-Deburr

0.00

2.29

> 2017/09/14
AP

4 0 2017/09/14 AP

110

110

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

4 0 17-09-15
BE

120

120

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

1.80

(4) 0 2017-09-18
JSL
BEB

Work Order ID 166246

166246

Page 2

Wednesday, September 13, 2017 11:07:26 A

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 Revision ID: Stop ***NS2***
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC7-Inspect Chemical Conversion Coat	0.00				4	0		JW
130									
QC	Memo	0.00							17-09-19
Quality Control									
140	Identify as per dwg & Stock Location: <u>LG002</u>	0.00				4	0		AP 2017/09/19
140									
Packaging	Memo	0.00							
Packaging	LOCATION : LG002								
150	QC21- Final Inspection - Work Order Release	0.00							17/9/20
150									
QC	Memo	0.00							
Quality Control									

SEP 19 2017

Picklist Print

Wednesday, September 13, 2017 11:07:29 AM

Page 1

Work Order ID: 166246

166246

Parent Item: D3505-1

D3505-1

Parent Item Name: Web

Start Date: 9/13/2017

Required Date: 9/18/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-05-30 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2963-125		Manufactured	No			120	Each	167.0000	1	4			
D2963-125									**				
105 I Beam Extrusion													

Location

Loc Qty

Loc Code

HALL

167

115870

1

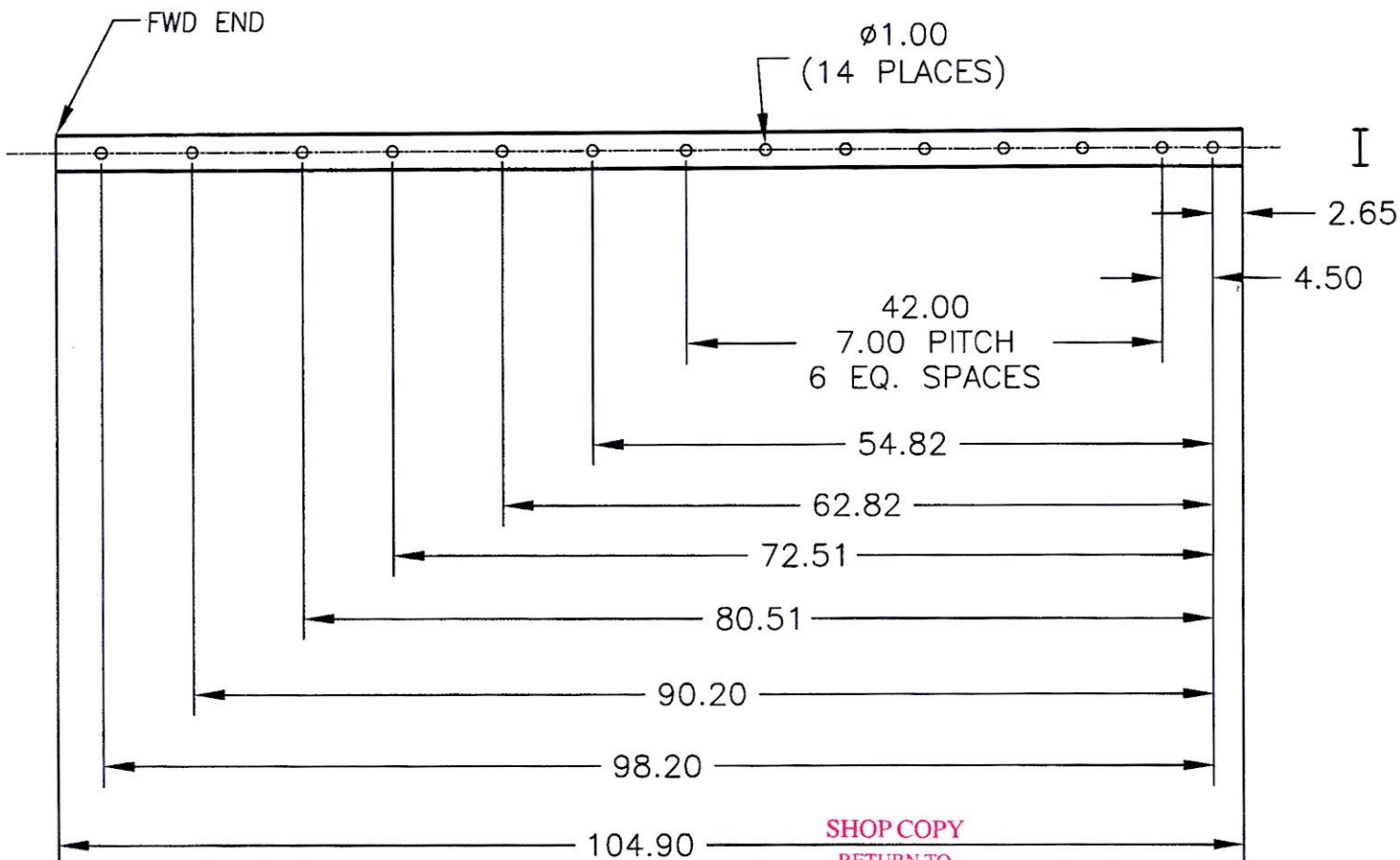
156872

166

4 2017/09/14 AP

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
		PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3505	SHEET 1 OF 1
DATE		TITLE	SCALE
06.04.21		WEB	1:15
A	06.04.21	NEW ISSUE	



D3505-1 WEB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166246
1209-13

D3505-1 WEB

- 1) MATERIAL: MAKE FROM D2963-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

RELEASED
06.10.02 #4
BY ECU #851